

Work Order ID 151277***151277***

Page 1

Monday, September 19, 2016 1:39:10 PM

Item ID: D2804-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 09/20/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 10/05/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2804	D

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.05

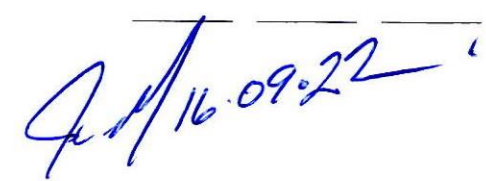
1-Cut as per File D2804-1-2_BLANK

Dwg Rev: _____

Prog Rev: _____

CHECK WITH MACHINIST FOR DIRECTION OF MATERIAL
BOW/WRAPPAGE PRIOR TO CUTTING

2-Deburr if necessary

N/A  9/16/16 09:22

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.29

Machine as per folio FA103

2  9/16/16 09:19

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>2</u>			<i>P16-09-19</i>
121 *121* Mill Conv Conventional Milling Machine	QC2- Inspect parts off machine FAI/FAIB Memo COUNTERSINK BACK SIDE AS PER DWG	0.00 0.00				<u>2</u>	<u>0</u>		DAS 32 9-89 <i>16-09-20</i>
122 *122* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>2</u>	<u>0</u>		DAS 32 9-89 <i>16-09-20</i>

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Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				2	Ø		DAS 44 9-8916-09-20
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.09				(x2)	Ø		2016/09/21 BEB
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				(2)			DAS 38 SEP 21 2016

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Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>w/o</u> Memo 151323	0.00 0.00				<u>2x</u>			<u>16/09/22</u>
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.03				DAS 21 9-89			SEP 22 2016

**DAS
21
9-89** **SEP 22 2016**

Picklist Print

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Page 1

Work Order ID: 151277

151277

Parent Item: D2804-2

D2804-2

Parent Item Name: Bracket

Start Date: 09/20/2016

Required Date: 10/05/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A00.11.06New IssueEC
IPP B06.05.30 Blanks on wtjetEC
IPP Rev:C As per Rev C 06-11-09 JLM
IPP Rev:D Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X12.00 0		Purchased	No				f	16.3300		2.8			

M6061T6B0 500X12 000

6061-T6 Bar .500 x 12.00

**

Location

Loc Qty

Loc Code

MAT

12

m131392

12

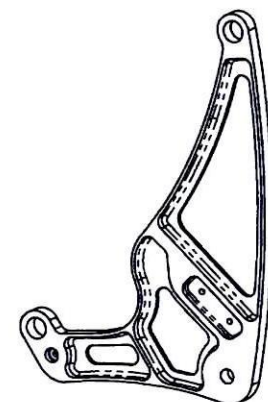
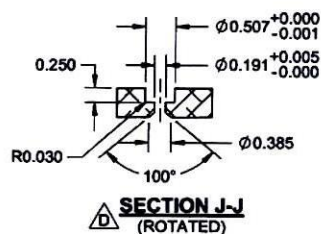
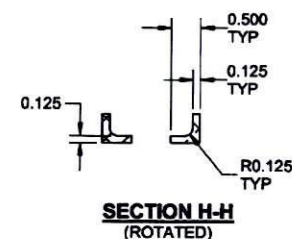
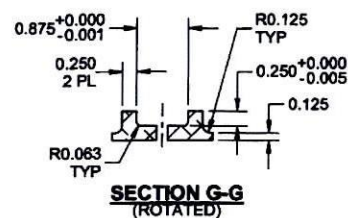
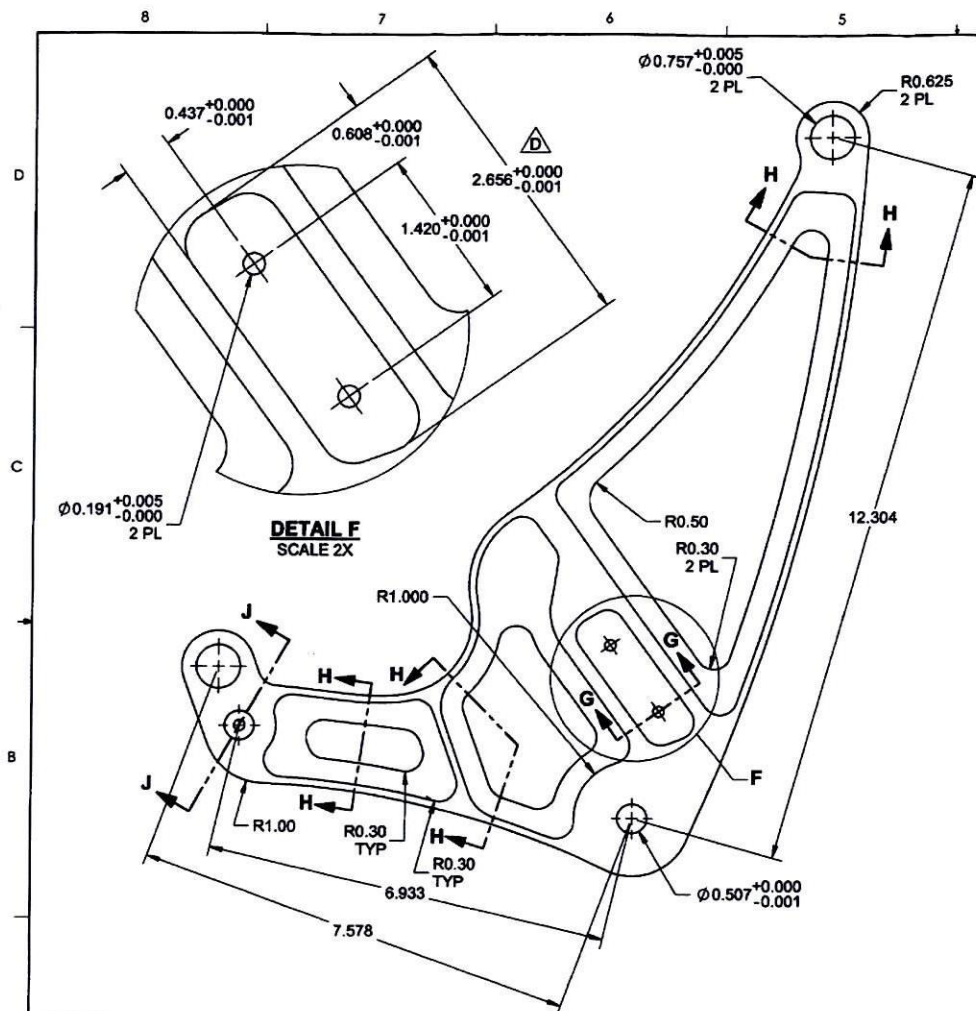
MAT001

4.33

m128866

4.33

 16-09-26



D2804-2 STA 155 BRACKET

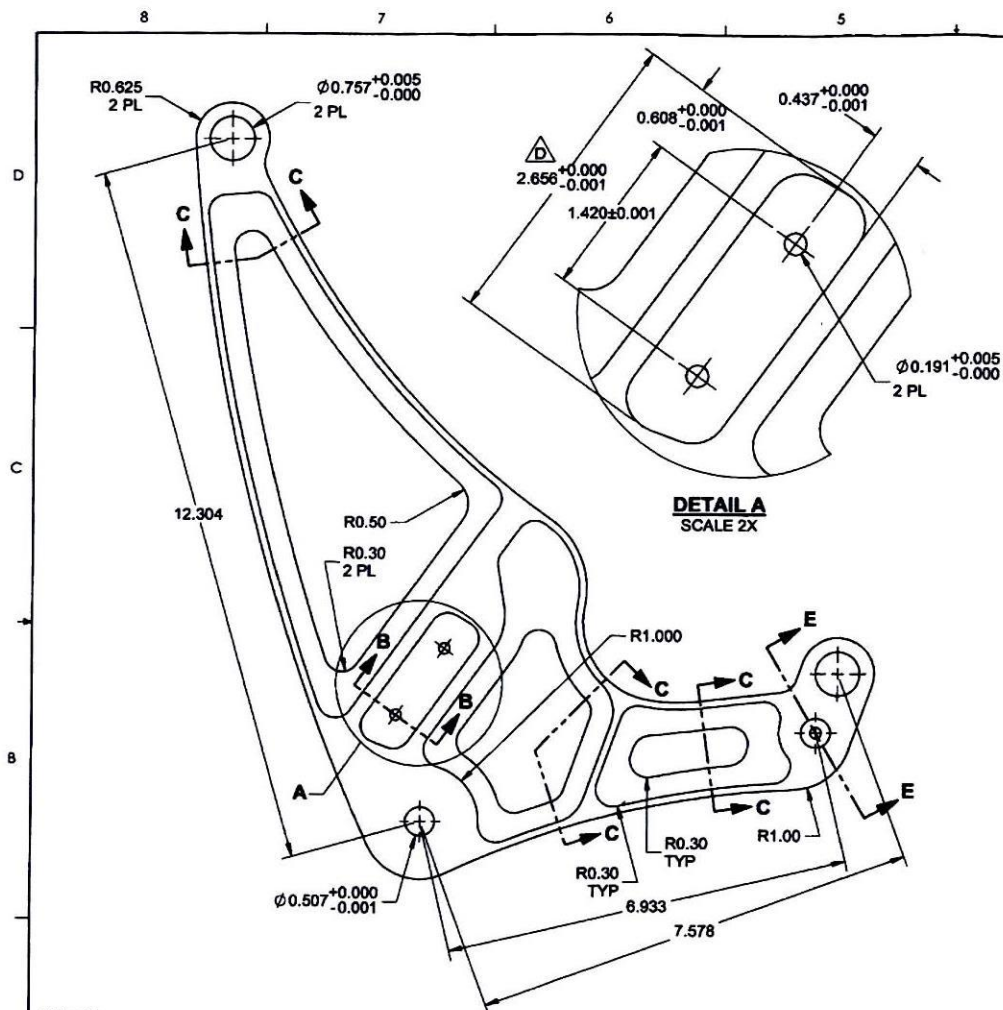
RELEASED

2016 JUN 22 d²

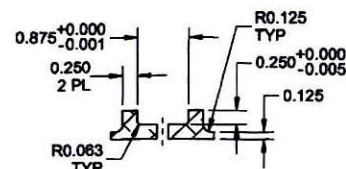
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: R0.030 TO 0.063 ON ALL EDGES
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.01 lbs
- 8) MACHINE PER PART FILE D2804-1_REV.D.SLDPR

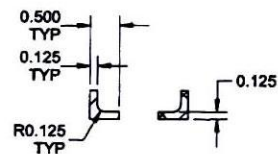
APPROVED	DESIGN	CP	DART AEROSPACE LTD	
	DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	ML	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D2804	SHEET 4 OF 4
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	STA 155 BRACKET	NTS
	DATE	16.04.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



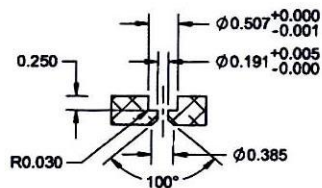
DETAIL A
SCALE 2X



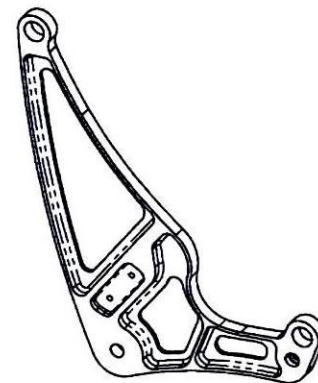
SECTION B-B
(ROTATED)



SECTION C-C
(ROTATED)



SECTION E-E
(ROTATED)



D2804-1 STA 155 BRACKET

RELEASED

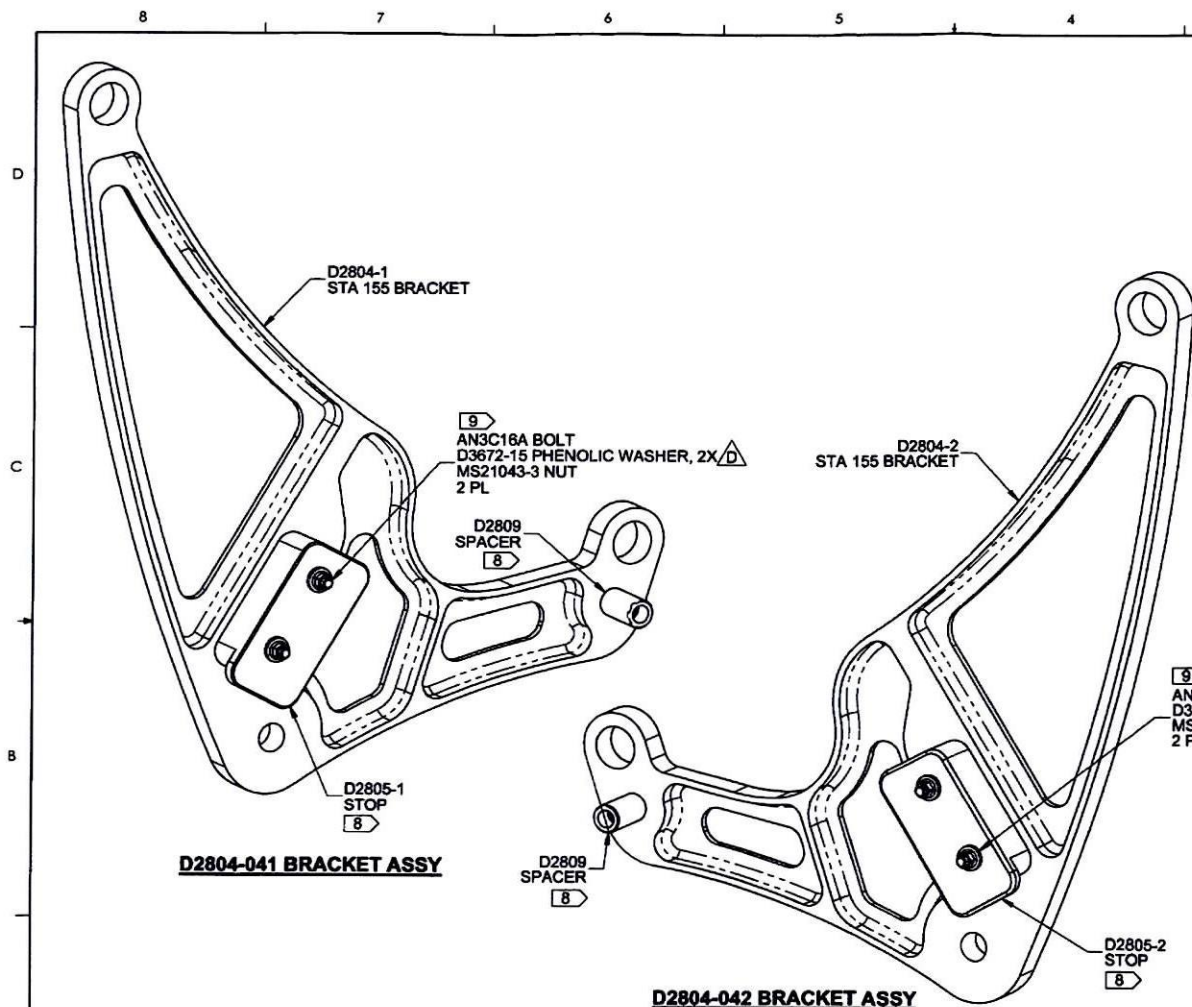
2016 JUN 22 qf

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: R0.030 TO 0.063 ON ALL EDGES
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.01 lbs
- 8) MACHINE PER PART FILE D2804-1_REV.D SLDPR

APPROVED

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2804	SHEET 3 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 155 BRACKET	NTS
DATE	16.04.11	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS RELEASED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D2804-041	BRACKET ASSY
		X	D2804-042	BRACKET ASSY
1	1		D2804-1	STA 155 BRACKET
2		1	D2804-2	STA 155 BRACKET
3	1		D2805-1	STOP
4		1	D2805-2	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDTEX" (4.3.5.6) OR "BLACK SANDTEX" (4.3.5.7) OR "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 1.37 lbs
 - 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
 - 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

D	REVISE TO CURRENT FORMAT: D3672-15 WAS NAS1516H3; MS21043-3 WAS MS21042-3; ADD CSINK (SECTIONS E-E AND J-J). REF: PAR16-499. D6-3/-4: 2.658 WAS 2.654 REASON: CAD ERROR.	MB	16.04.11
C	CHANGE GEOMETRY TO ADD CLEARANCE	CP	06.10.16
B	ADD CUTOUTS AND -043/-044	CP	04.11.22
A	NEW ISSUE	CP	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2804 TITLE STA 155 BRACKET	
DRAWN	MB		
CHECKED	ML		
MFG. APPR.	JLM		
APPROVED	WM		
DE APPR.	DS	REV. D SHEET 1 OF SCALE NTS	
DATE	16.04.11	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

